

# Work Order ID 63645

Monday, November 08, 2010 11:36:20 AM

Page 1

Item ID: D2512

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid 205/350

Start Date: 11/8/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/16/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-08

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 11385 0.00



Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

4-Weld as per Dwg D2512 using Welding Jig DT 9436

Deburr as required

\*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

SAD 10-11-08

lpl 10-11-23

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

BE 10-11-24

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

8/10/124

70

125



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

=&gt; 10/11/25

1 0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 9:00

OVEN TEMPERATURE: 400°

FINISH TIME: 9:30

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

1. BL 10-11-25.

140



HandFinish

Hand Finishing

HandFinishing

0.00 => 10/11/25

Memo

0.00

✓ Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4  
Batch: M115790 M115193

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 63645**

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Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*EP 10/11/26 @*

160

Identify as per dwg & Stock Location: *C-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o  
63643 (1x)**EP 10/11/26 @*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/11/26 @**ME  
10-11-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, November 08, 2010 11:36:29 AM

Page 1

Work Order ID: 63645

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 11/8/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

**Comments:**  
 Rev IPP:M03.01.31 AddedD2012-117forD130-701-041 KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC  
 added pressure wash DD verf:EC  
 IPP Rev:R 10.06.29

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	28.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Clevis

Location	Loc Qty	Loc Code
WA	28	
3091	1	
55729	27	

\*\*\* ONLY APPLICABLE ON D130-701-041 -IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1		Manufactured	No			100	Each	22.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Basket Hinge

Location	Loc Qty	Loc Code
WA	22	
55791	22	

D2327-1		Manufactured	No			100	Each	21.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Spacer Bushing

Location	Loc Qty	Loc Code
WA	21	
54658	9	
60174	12	

*M/A*

*2*  
*Pl 10-11-23*

*2*  
*Pl 10-11-23*

*2*

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Page 2

Work Order ID: 63645

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 11/8/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

2.0000

1

1



Label Plate



*Pl 10.11.23*

Location

Loc Qty

Loc Code

WA

2

61464

2

D2581

Manufactured No

100

Each

23.0000

2



Mounting Bracket



*①*  
*Pl 10.11.23*

Location

Loc Qty

Loc Code

WA

23

60470

3

61953

20

D3166-3

Manufactured No

100

Each

8.4231

1

1



Basket Hoop



*363493 → ②*  
*SAD 10-11-10*

Location

Loc Qty

Loc Code

WA

8.423071053

55697

2.1053E-05

59266

0.0418

60270

0.00265

61193

2.3786

63063

6

Monday, November 08, 2010 11:36:29 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Parent Item Name: Basket Lid 205/350



Start Date: 11/8/2010

Required Date: 11/16/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

1,020.601

18

18.94737



Expanded Metal Flat SS



*Pl 10.11.22*

## Location

## Loc Qty

## Loc Code

MAT

1020.601033

114809

139.403243

114853

11.80059

115012

395.1315

115067

13.0125

115171

6.0394

115401

76.0095

115665

59.2043

115989

320

M304TS0.750W.065

Purchased

No

100

f

443.4357

43.5804

45.87411



304 SQ Tube .75x.75x.065W



*18.94737*

*SAD 10-11-22*

## Location

## Loc Qty

## Loc Code

MAT

301.88145

112398

0

114482

0.0002

115494

19.4726

115593

282.40865

WA

141.554285

115274

4.712185

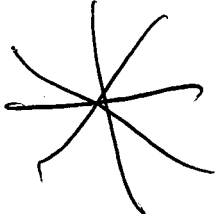
115901

136.8421

*15.00*



*30.87411*



Monday, November 08, 2010 11:36:29 AM

Shop Packet Print

Page 3

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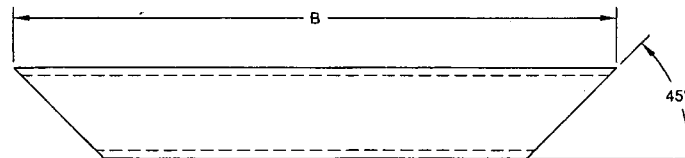
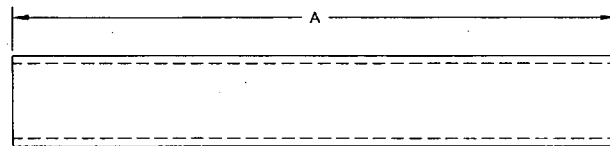
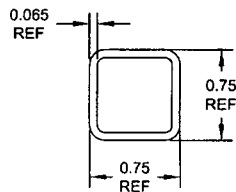
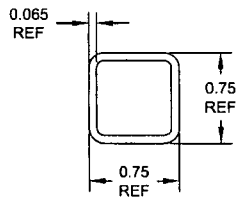
**NOTE:** Date & initial all entries

# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 6364-5  
B810-1101

RELEASED  
08.08.21/11



## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	1	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2512	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

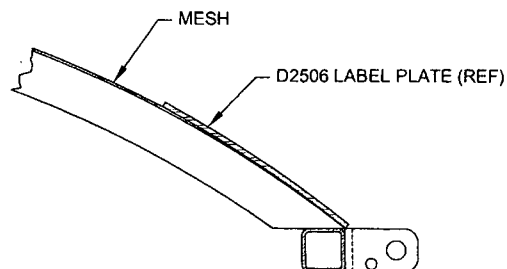
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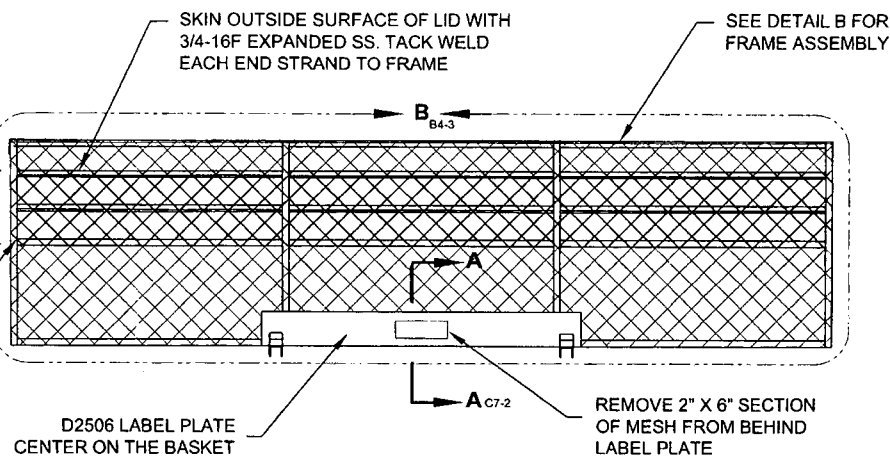


**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)



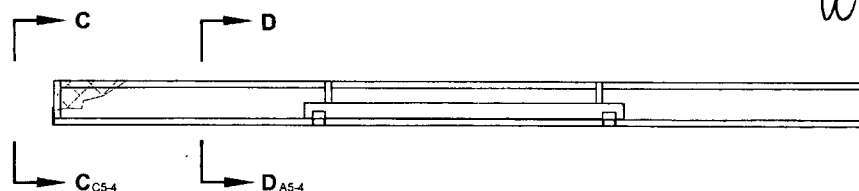
FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



*W/O 4364/5*

**RELEASED**  
05.05.21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

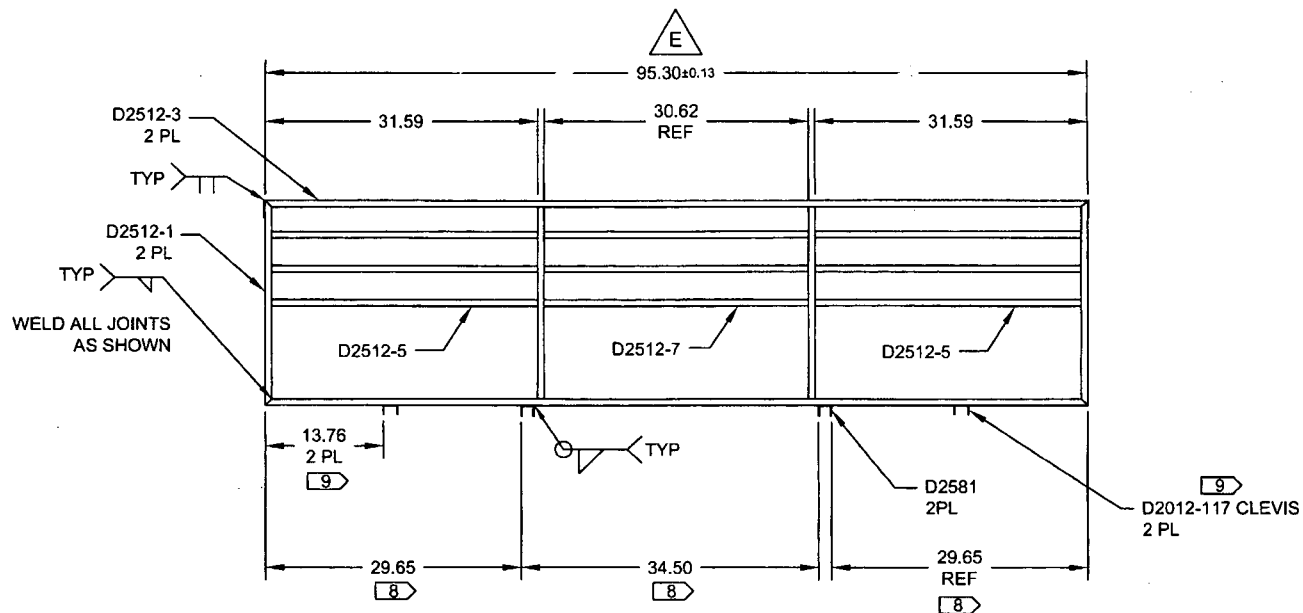
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

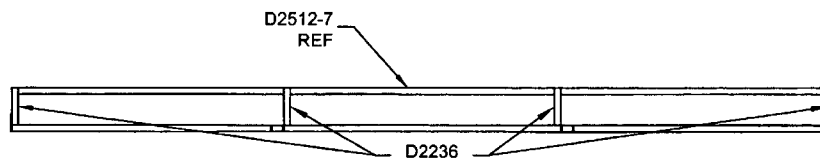
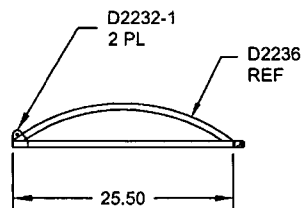
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



*w/o 63645*

**RELEASED**  
08-06-17

- NOTES:**
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A
  - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
  - 9) FOR D130-701-041 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	D	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	11	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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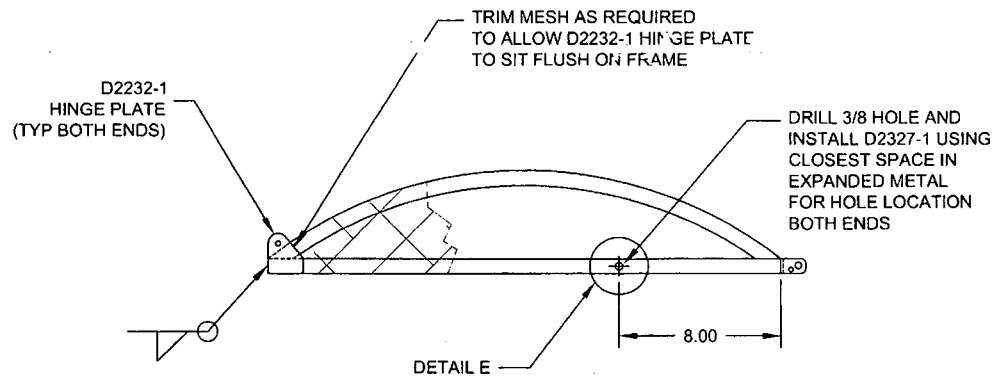
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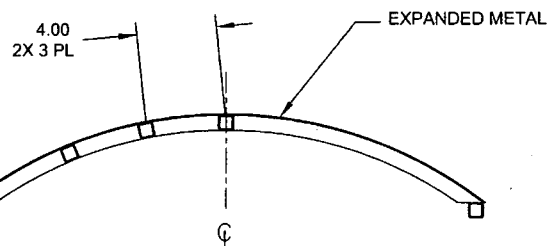
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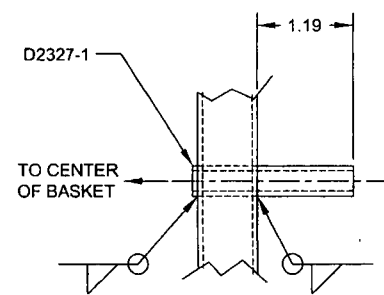


**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2

*u/b 43645*



**DETAIL E** C6-4

**RELEASED**  
08-06-17

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries